

Work Order ID 130923

Friday, March 27, 2015 2:53:42 PM

130923

Page 1

Item ID: D4011-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp, Short
 Start Date: 3/26/2015 Start Qty: 120.00 ***120*** Cust Item ID:
 Required Date: 3/26/2015 Req'd Qty: 120.00 ***120*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-03-27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4011	C								

100

0.00

100

Waterjet

FLOW CNC Waterjet

304.080"

~~PURCHASING~~

Memo

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

126 Ø Jm 15-3-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

126 Ø Jm 15-3-30

Work Order ID 130923***130923***

Friday, March 27, 2015 2:53:42 PM

Page 2

Item ID: D4011-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp, Short

Start Date: 3/26/2015 Start Qty: 120.00

120

Cust Item ID:

Required Date: 3/26/2015 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamps

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

126DAS
38
9-89
APR 1 2015

130

Form as per dwg
NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89**126X**DAS
28
9-89

APR 01 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

126DAS
38
9-89

APR 06 2015

Work Order ID 130923

130923

Page 3

Friday, March 27, 2015 2:53:42 PM

Item ID: D4011-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp, Short
 Start Date: 3/26/2015 Start Qty: 120.00 *120* Cust Item ID:
 Required Date: 3/26/2015 Req'd Qty: 120.00 *120* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>S/S42</u>	0.00				126	DAS 27 9-29		
150	Packaging Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160	QC Memo	0.00							
Quality Control									

APR 07 2015

MCS 1504-03

APR 5-4-7

Picklist Print

Friday, March 27, 2015 2:53:45 PM

Page 1

Work Order ID: 130923

130923

Parent Item: D4011-1

D4011-1

Parent Item Name: Clamp, Short

Start Date: 3/26/2015

Required Date: 3/26/2015

Start Qty: 120.00

Required Qty: 120.00

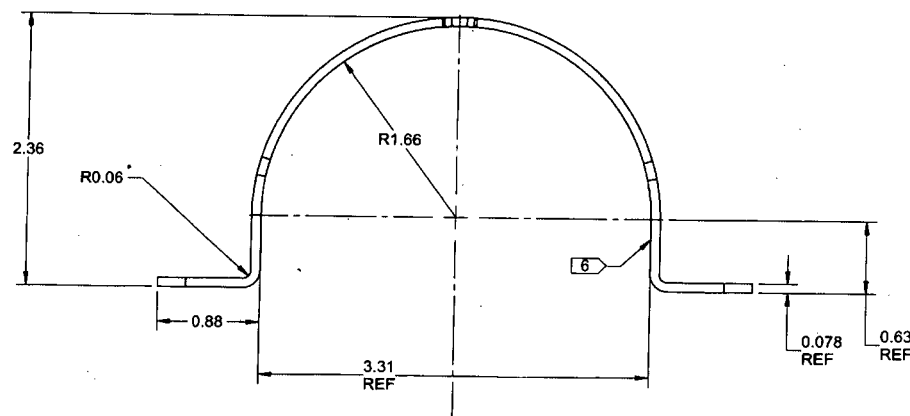
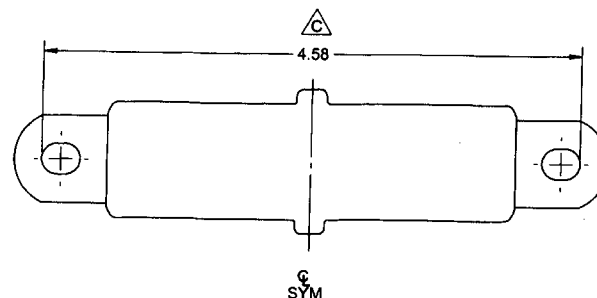
Comments:

IPP RevA: New issue DD verified by:EC

IPP Rev:B

11.05.19 MADE IN HOUSE DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased		No		100	sf	170.0000	0.07	12			
M304S14GA										**	12	Jm15-3-28	
304SS sheet .080													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT019		170					
						M126075		48					
						M129972		122			126075.		



D4011-1 CLAMP, SHORT

RELEASED

2015 MAR 26

4 EN 11-532



NOTES:

- 1) MATERIAL: MAKE FROM D4011-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-1" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs

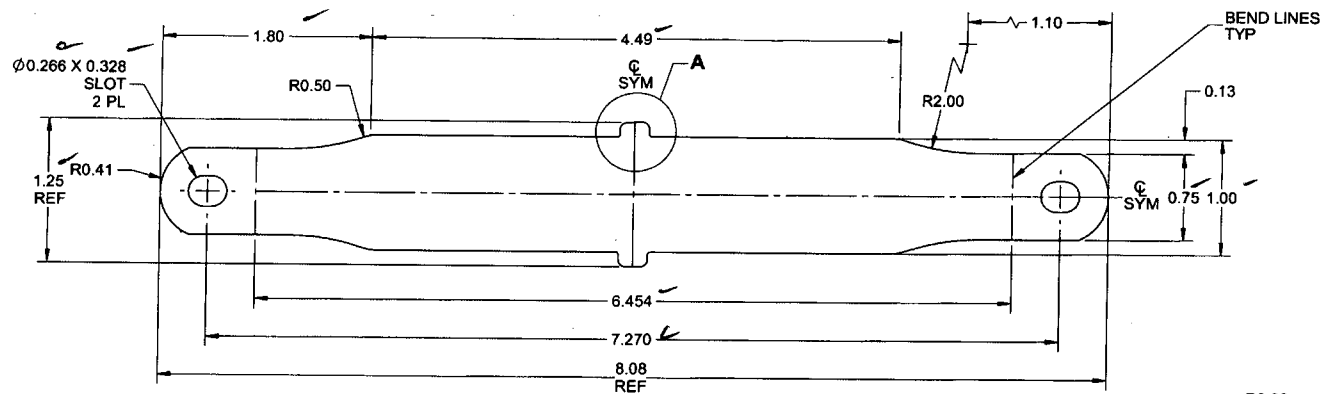
S. 1
K. 1
UNCONTROLLED COPY
SUBJECT TO A
WITHOUT
ORDER

130923 MLW

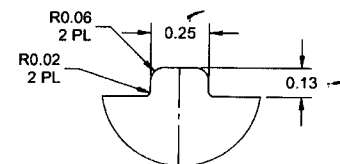
1503-27

C	ADD SLOT HOLES, ADD CUSHION RETENTION DETAILS TO -1/-3/-5 CLAMPS, REASON: PAR 14-331, NCR 14-3521, PAR 14-388, ZND5-1, A8-1, B8-2, B2-2, D4-3, A8-3, B8-4, B2-4, D5-5, A8-5, B8-6, B2-6, REVISE NOTE 6: ZN A8-2, A8-4, A8-6	VS	14.09.22
B	SHORTEN HEIGHT OF -1/-3 CLAMPS BY 0.125; ADDED -5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D4011-1F CLAMP, FLAT PATTERN SHORT



DETAIL A
SCALE 2X
2 PL

RELEASED

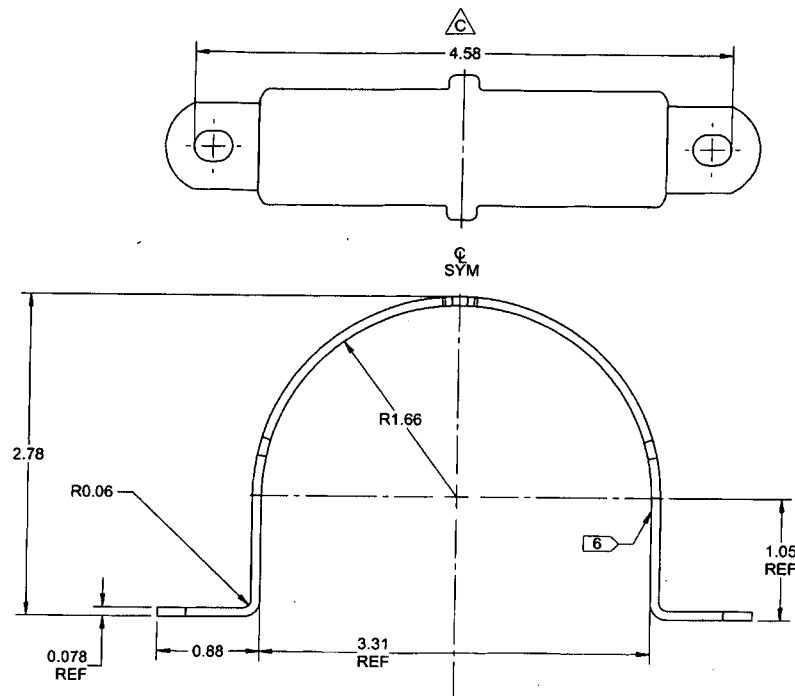
2015 MAR 26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-1F-RevC.DXF

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D4011-3 CLAMP, LONG

RELEASED

2015 MAR 26 *q*

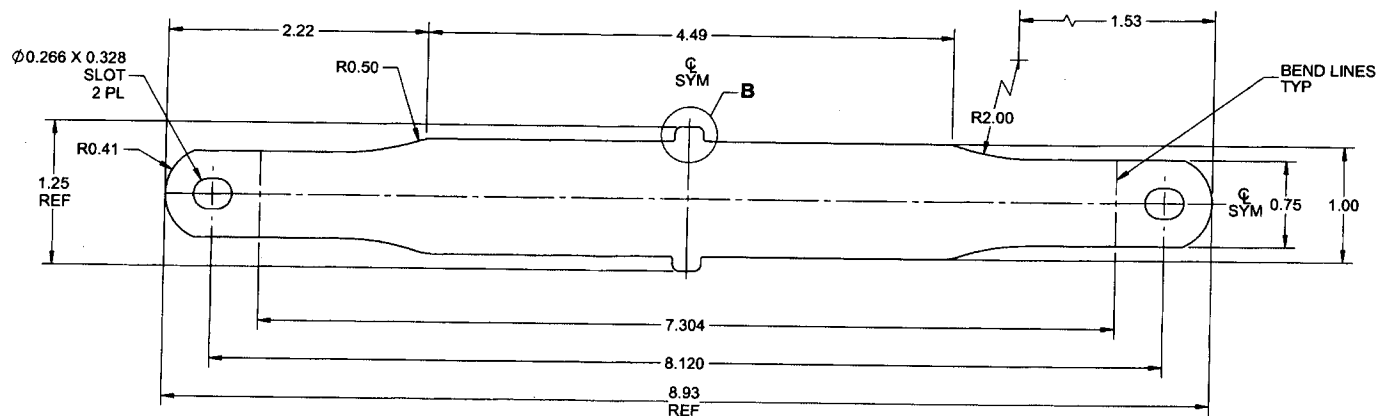
APPROVED

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DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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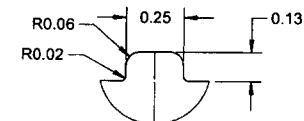


NOTES:

- 1) MATERIAL: MAKE FROM D4011-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-3" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs



D4011-3F CLAMP FLAT PATTERN, LONG



DETAIL B
SCALE 2X
2 PL

RELEASED

2015 MAR 26 *qp*

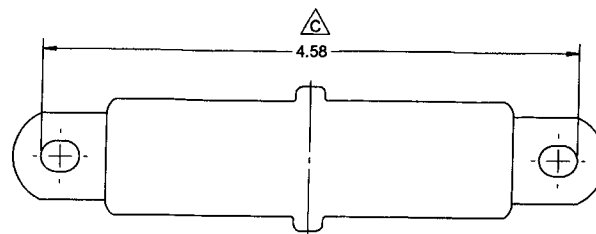
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-3F-RevC.DXF

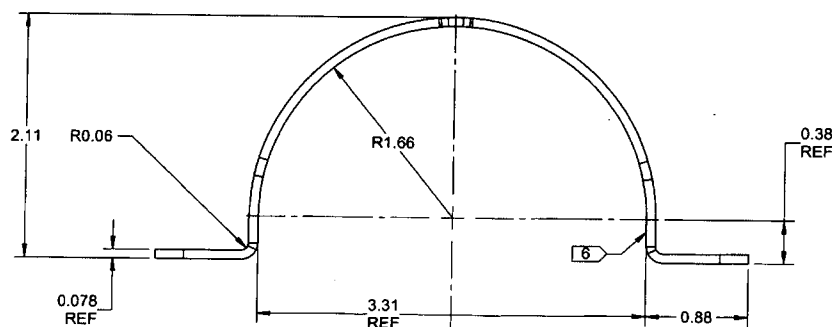
APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VS	
CHECKED	RF	DRAWING NO. D4011 REV. C
MFG. APPR.	DD	SHEET 4 OF 6
APPROVED	HS	TITLE CLAMP SCALE NTS
DE APPR.	DS	
DATE	14.09.22	

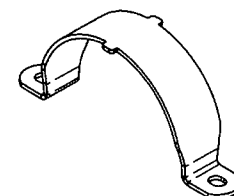
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C
SYM



D4011-5 CLAMP, SHORT (OEM)



NOTES:

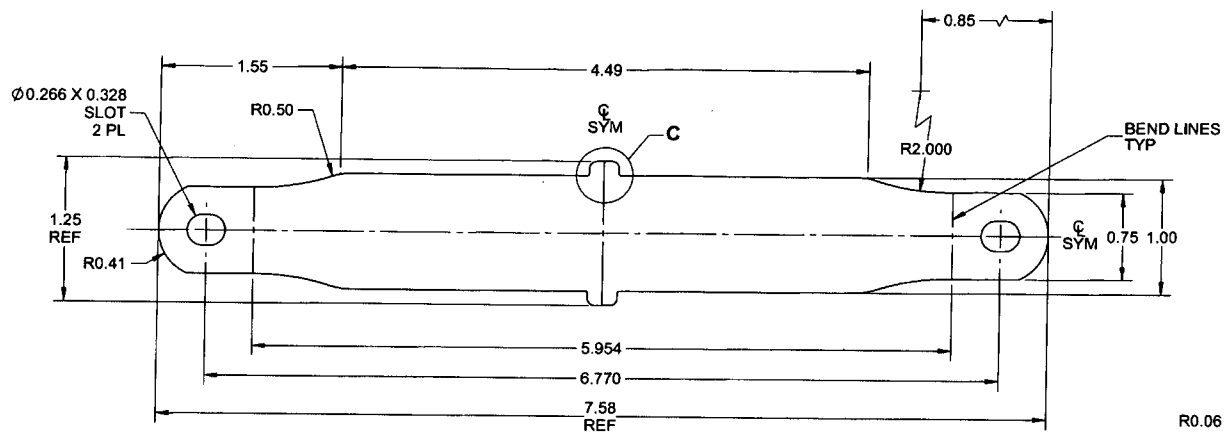
- 1) MATERIAL: MAKE FROM D4011-5F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-5" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs

RELEASED

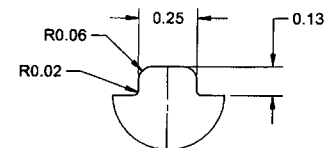
2015 MAR 26 *up*

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VS	
CHECKED	RF	DRAWING NO. D4011
MFG. APPR.	DD	REV. C SHEET 5 OF 6
APPROVED	HS	TITLE
DE APPR.	DS	CLAMP SCALE NTS
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D4011-5F CLAMP, FLAT PATTERN, SHORT (OEM)



DETAIL C
SCALE 2X

RELEASED

2015 MAR 26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-5F-RevC.DXF

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
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